

Work Order ID 144822

April 25, 2016 2:20:16 PM

144822

Page 1

Item ID: D206-797-211 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH
 Start Date: 5/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160425 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-797-2	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD206-797-211 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
28
9-89

MCS 16-04-28

2X DAS 28 9-89 MAY 02 2016

2 APR 29 2016

DAS 27 9-89

2X DAS 28 9-89 MAY 02 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Work Order ID 144822

April 25, 2016 2:20:16 PM

144822

Page 2

Item ID: D206-797-211 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH
 Start Date: 5/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-797-211 Location: FG034								
	<i>x1 FS 034</i> <i>1x PPP 143876</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

2x

DAS
28
9-89

DAS
27
9-89

MAY 02 2016

MS

MAY 02 2016

2m

16/05/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																	
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																	
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																	
Large Fab ☐	Composite ☐	Supplier ☐																																																																		
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																
Description Work Order Deviation		Disposition		Completed By																																																																
				Lead hand / Supervisor Approval Verification																																																																
				QC / QA Coordinator Approval																																																																
Root Cause		FAULT CATEGORY																																																																		
<table style="width: 100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>	Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td></tr> <tr><td style="border: none;">Bending ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td></tr> </table>	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	<table style="width: 100%; border: none;"> <tr><td style="border: none;">Temperature/Cure ☐</td><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Set-up ☐</td><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">BOM/Route ☐</td><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Broken/Damage/Defect ☐</td><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Inspection Incomplete/Unqualified ☐</td><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Contamination ☐</td><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Countersink ☐</td><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Cut Too Short ☐</td><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Instructions Incomplete/Unclear ☐</td><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Drill Holes ☐</td><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>			Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																			
Design ☐	Operator ☐																																																																			
Doc/Data ☐	Offset/Setup ☐																																																																			
Equip/Tooling ☐	Supplier ☐																																																																			
Handling/Pre ☐	Training ☐																																																																			
Material ☐	Use for Testing ☐																																																																			
Internal Transport ☐	Poor Information ☐																																																																			
Tribal Knowledge ☐	Rushing ☐																																																																			
LOA ☐	Product Improvement ☐																																																																			
Substation ☐	Process Improvement ☐																																																																			
Past Expiry Date ☐	Manufacturing Process ☐																																																																			
Misidentified ☐	Past Due ☐																																																																			
Pressure/Forced ☐																																																																				
Bending ☐																																																																				
Centre Not Concentric ☐																																																																				
Cracks ☐																																																																				
Crimp/Kink/Ripple/Wave ☐																																																																				
Cuffs ☐																																																																				
Crushing ☐																																																																				
Heat Treat ☐																																																																				
Wave/Twist in Tube ☐																																																																				
Marks/Chatter ☐																																																																				
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER : ☐																																																																				

Picklist Print

April 25, 2016 2:20:21 PM

Page 1

Work Order ID: 144822

144822

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 5/10/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:B
11.04.18 MS24694-10 TO MS24694-S10 DD verf:JLM IPP Rev:C 11.04.19
added(1) D4293-1(was missing) DD verf:JLM IPP Rev:D 11.09.12 @ chg
002 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
D4713-1		Manufactured	No			110	Each	6.0000	1	42			DAS 6 9-89
D4713-1													DAS 27 9-89
Spacer													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST121				6					
				138743				6					
MS3367-5-0		Purchased	No			110	Each	94.0000	1	42			DAS 6 9-89
MS3367-5-0													DAS 27 9-89
Tie Wrap													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272				94					
				123164				94					
D4271-011		Manufactured	No			110	Each	2.0000	1	42			DAS 6 9-89
D4271-011													DAS 27 9-89
Beam Assembly, Fwd													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST452				2					
				131781				2					

APR 29 2016

Picklist Print

April 25, 2016 2:20:21 PM

Page 2

Work Order ID: 144822

144822

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 5/10/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

D4271-013

Manufactured No

110

Each

3.0000

1

1

D4271-013

Beam Assembly, Aft

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST453

3

122880

1

131697

1

141297

1

D4292-1

Manufactured No

110

Each

6.0000

2

2

D4292-1

Fitting

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st533

6

119389

1

123358

5

D4293-1

Manufactured No

110

Each

16.0000

2

2

D4293-1

Fitting

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

st533

16

114227

2

116905

4

122955

8

97520

2

D4314-1

Manufactured No

110

Each

34.0000

4

D4314-1

Shim

DAS
6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST091

34

120515

14

123102

20

APR 29 2016

April 25, 2016 2:20:21 PM

Shop Packet Print

Page 2

Picklist Print

April 25, 2016 2:20:21 PM

Page 3

Work Order ID: 144822

144822

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 5/10/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

D4314-3

Manufactured No

110

Each

51.0000

4

28

**

DAS
6
9-89
27
9-89

D4314-3

Shim

Location

Loc Qty

Loc Code

ST091

4

116106

4

ST103a

47

113351

18

119651

9

123115

20

4
4

AN6-17A

Purchased

No

110

Each

22.0000

2

24

**

DAS
6
9-89
27
9-89

AN6-17A

Bolt

Location

Loc Qty

Loc Code

ST334

22

m128403

7

m130466

15

24
24

AN6-20A

Purchased

No

110

Each

37.0000

2

**

DAS
6
9-89
27
9-89

AN6-20A

BOLT

Location

Loc Qty

Loc Code

over005

30

M133932

30

ST334

7

M128936

7

24

DAS
28
9-89

April 25, 2016 2:20:21 PM

Shop Packet Print

Page 3

Picklist Print

April 25, 2016 2:20:21 PM

Page 4

Work Order ID: 144822

144822

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 5/10/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

576.0000

8

8/16

NAS1149D0663.J

Washer

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST263

298

M133134

89

M133769

12

M133812

6

M134360

191

ST269

51

M126334

51

DAS
28
9-89

DAS
27
9-89

MS21042L6

Purchased

No

110

Each

229.0000

4

48

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST303

229

m133938

6

m134055

73

m134509

100

m134567

50

DAS
28
9-89

DAS
27
9-89

MS27151-19

Purchased

No

110

Each

75.0000

4

48

MS27151-19

NUT

Location

Loc Qty

Loc Code

ST275

75

m128994

5

m132285

20

m132399

50

DAS
28
9-89

DAS
27
9-89

April 25, 2016 2:20:21 PM

Shop Packet Print

Page 4

Picklist Print

April 25, 2016 2:20:21 PM

Page 5

Work Order ID: 144822

144822

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 5/10/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS24694-S10

Purchased

No

110

Each

144.0000

4

48

MS24694-S10

SCREW

DAS 27
6 9-89
27 9-89

Location

Loc Qty

Loc Code

ST284

144

117442

44

120986

100

9

DAS
28
9-89

April 25, 2016 2:20:21 PM

Shop Packet Print

Page 5

Work Order ID 144822

April 25, 2016 2:20:16 PM

144822

Page 1

Item ID: D206-797-211 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH
 Start Date: 5/10/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SH 20160425 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-797-2	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD206-797-211 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

MCJ APR 28 2016

[Handwritten mark]

5.0 PARTS LIST

Qty -021	Qty -022	Qty -023	Qty -024	Qty -211	Part Number	Description
X					D206-797-021	QUICK RELEASE HELI-UTILITY-BASKET
	X				D206-797-022	QUICK RELEASE HELI-UTILITY-BASKET
		X			D206-797-023	QUICK RELEASE HELI-UTILITY-BASKET
			X		D206-797-024	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D206-797-211	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4293-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP